

Work Order ID 62109

Thursday, September 16, 2010 8:53:06 AM



Page 1

Item ID: PB67-43001-235

Accept



Setup Start



Revision ID:

Stop



Item Name: Outer Tube

Start Date: 9/16/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 9/30/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 10-9-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								
100		0.00							
	BAND SAW					2	0		
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	1- cut to length as per dwg 2- deburr								
	<i>SA 10/09/25</i>								
110		0.00							
	CONVENTIONAL MILLING MACHINE					2	0		<i>P10</i>
Mill Conv	Memo	0.00							
Conventional Milling Machine	1- drill holes and mill slot as per dwg PB67-43001 2- deburr								
	<i>* A18792</i>								
120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
	<i>SA 10/02/27</i>								
	<i>(x2)</i>								

Dart Aerospace Ltd

W/O: 62109		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/05/25	110	Perm cve Add N18792 inks	SA [Signature]	10/05/25 10.09.27			S 10/05/27	

Part No: PB67-43001-235 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Accept

Revision ID:

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Start Date: 9/16/2010 Start Qty: 2.00

Required Date: 9/30/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

*BOT
AURP
SURT210*

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/16/10 *(2)**10/19/10**CL1019127*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 62109

Parent Item: PB67-43001-235

Parent Item Name: Outer Tube



Start Date: 9/16/2010

Required Date: 9/30/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-24 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.750W.065		Purchased	No			100	f	42.6590	5.3125	11.18421			
6061T6 RDTUBE 1.750 X 0.65W													

Location

Loc Qty

Loc Code

MAT016

42.659

108551

2.66

109397

6.958

110885

16

111432

17.041

10, 7 24 SA 10/09/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 62109
Description: Outer Tube		Part Number: PB67-43001-235
Inspection Dwg: 1367-43001 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
63.75	±.030	63.75	✓		Tape	SA-1
50.62	--	50.62	✓			
49.75	--	49.75	✓			
48.75	--	48.75	✓			
8.25	--	8.25	✓			
.75	--	.752	✓			
1.50	--	1.50	✓			
.50	--	.50	✓			
.745	±.010	.745	✓			
52.25	±.030	52.25	✓			
Ø 1.75	±.030	1.75	✓		Depth	SA-2
Ø .250	+ .006 - .001	Ø .250	✓		7	7
Ø .125	+ .006 - .001	Ø .127	✓			

Measured by: SA	Audited by: S	Prototype Approval: N/A
Date: 10/09/26	Date: 10/09/27	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

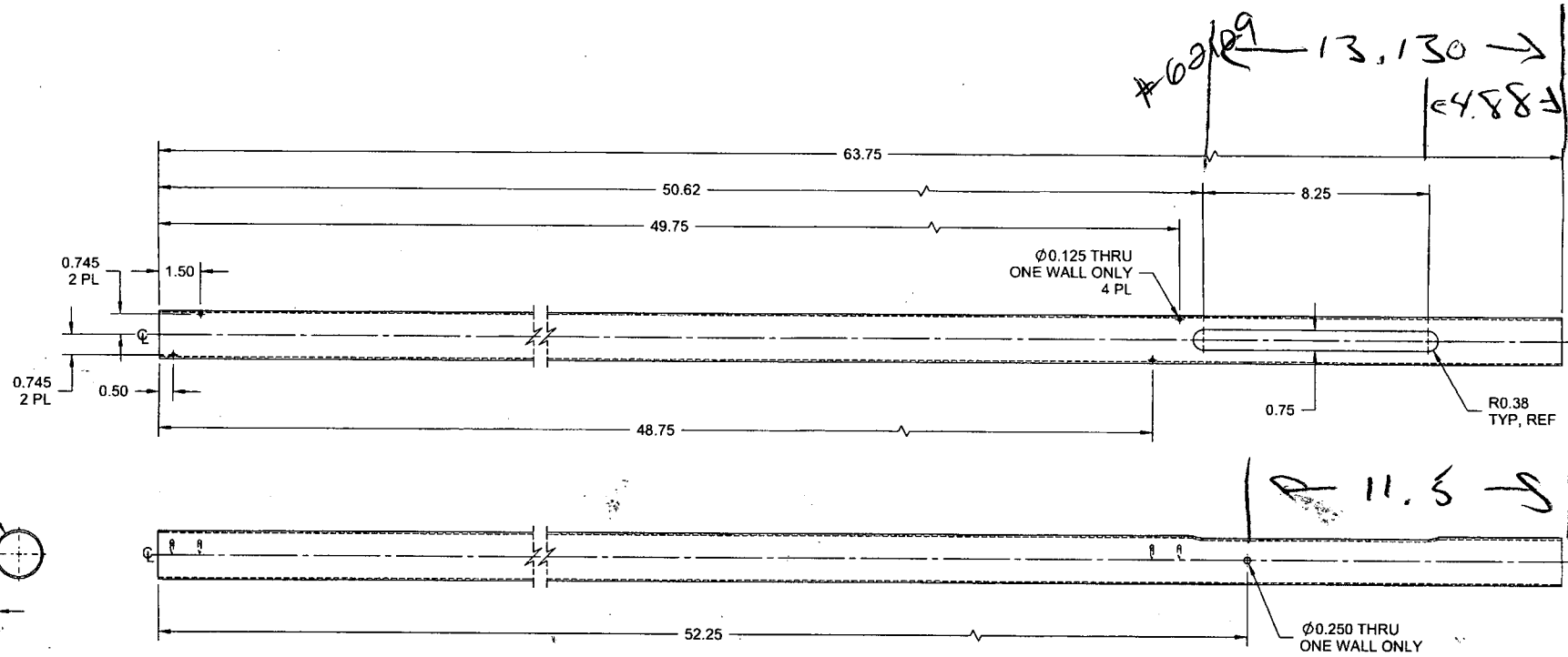
8 7 6 5 4 3 2 1

D

C

B

A



B67-43001-235 OUTER TUBE

RELEASED
2009-09-24
MP

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8 REF. DART SPEC. M6061T6T1.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.10 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 19 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS			
CHECKED	AS	DRAWING NO.	REV. C	
MFG. APPR.	AS	B67-43001-235	SHEET 1 OF 1	
APPROVED	AS	TITLE	SCALE	
DE APPR.	N/A	OUTER TUBE	NTS	
DATE	09.02.27		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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